

Split

Work Order ID 97854-1

97854

Page 1

March-01-13 8:48:32 AM

Item ID: D2582

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Leg Assembly

Start Date: 3/01/13

Start Qty: ~~10.00~~ 5

10

Cust Item ID:

Required Date: 3/22/13

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 13-08-01

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2582

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2582 and

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: WA 003

0.00

120

Packaging

Memo

0.00

Packaging

5x

13.06.26

5

φ

DAS
19
8-83

5

φ

13.06.26

Work Order ID 97854***97854***

Page 2

March-01-13 8:48:32 AM

Item ID: D2582

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg Assembly

Start Date: 3/01/13

Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/22/13

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

13/01/2013

Picklist Print

March-01-13 8:48:31 AM

Page 1

Work Order ID: 97854

Parent Item: D2582

Parent Item Name: Step Leg Assembly

Start Date: 3/01/13

Required Date: 3/22/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:F Removed Manufacturing 05-11-07 JLM
IPP Rev:G Added part # to Sub 06-08-10 JLM
IPP Rev H New pick list 08.01.11 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2278 Step Leg		Manufactured	No			100	Each	6.0000	2	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				89313		6							
D2279 Step Spacer		Manufactured	No			100	Each	41.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		41							
				73048		2							
				86718		12							
				90014		27							
D2322 Step Spacer		Manufactured	No			100	Each	12.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		12							
				67611		4							
				90051		8							
D3720-1 Step Spacer		Manufactured	No			100	Each	29.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		29							
				87656		9							
				90176		20							
D3720-2 Step Spacer		Manufactured	No			100	Each	15.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		15							
				89810		15							

Handwritten notes and signatures:

- Signature: [Signature]
- Date: 3/06/26
- Text: B97981 (circled)
- Text: B97944 (circled)
- Text: 41
- Text: 41
- Text: 41
- Text: 5

Picklist Print

March-01-13 8:48:32 AM

Page 2

Work Order ID: 97854

Parent Item: D2582

Parent Item Name: Step Leg Assembly

Start Date: 3/01/13

Required Date: 3/22/13

Start Qty: 10.00

Required Qty: 10.00

MS20470AD4-4

Purchased

No

100

Each

1,748.0000

22

220

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

72

121652

72

ST336

1676

116188

136

118614

251

122027

677

124231

612

MS20470AD4-5

Purchased

No

100

Each

1,607.0000

4

40

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

528

122452

528

ST336

1079

122452

1079

EP 3/06/13

M125268 (110)

EP 3/06/13

M124654 (20x)

March-01-13 8:48:32 AM

Shop Packet Print

Page 2

D2278 STEP LEG
(2 PLACES)

MS20470AD4-4 RIVET
(5 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2279 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET
(6 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET
(2 PLACES)

MS20470AD4-5 RIVET
(2 PLACES)

D3720-2 STEP SPACER

D3720-1 STEP SPACER

C'SINK ON INSIDE
GRIND RIVET FLUSH TO
SURFACE AS REQUIRED
(BOTH SIDES)

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

SHOP
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO
WITHOUT
WORKING
NO. 97854 ML5
13-03-01

RELEASED
05-01-10

REV. B	REPLACE D2280 SPACERS WITH D3720-1/-2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
REV. A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED	LG		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.12.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D2582 SHEET 1 OF 1
TITLE DATE
STEP LEG ASSEMBLY NTS

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